

Date: Wednesday, 3/21/2007 3:40:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 31407C	
Estimate Number : 10354	
P.O. Number : <i>N/A</i>	Part Number : D2322
This Issue : 3/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2322 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 30813C	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/10/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: *1104025* *ml 07 06 16*

20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2322
 Dwg Rev: *C*
 Prog Rev: *C*

ml 07 06 16

20

2-Deburr if necessary

ml 07-06-25

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 06 16

20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07/06/18

20

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D2322

S/S 07/06/29

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 8/10/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 31407C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/06/29

(470) counted

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fz 07/06/29 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ep 07/07/03 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ep 07/07/03 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) R 07/07/03

Job Completion



CU 07-0703

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
Bw		CP		HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	WHT	DRAWING NO.	REV. C
DATE		TITLE		SHEET 1 OF 1	
98.09.29		STEP SPACER		SCALE	
A		94.10.14		1:2	
C		98.09.29		4.428 WAS 4.460, 0.040 WAS 0.032	
				CHANGES PER NCR 001	

RELEASED
98.10.08 DS

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

OK CP 01/11/99

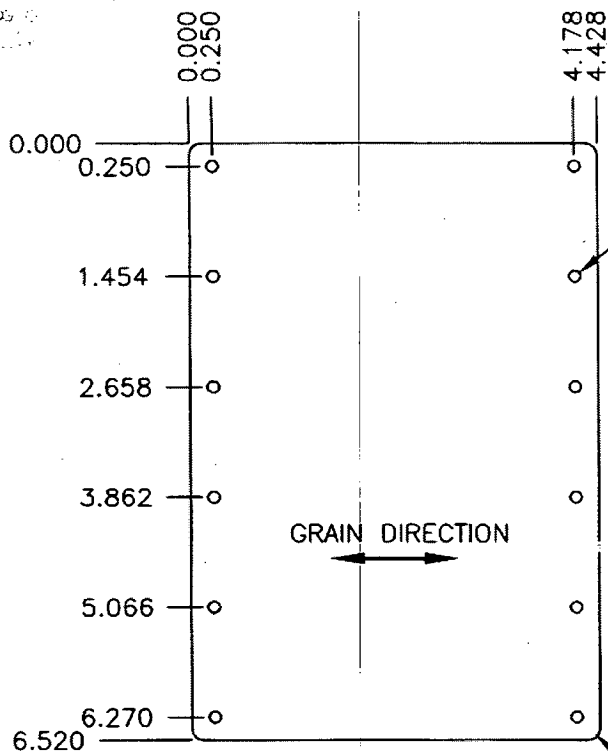
KE 98.09.06

R0.125
(TYP 4 PLACES)

Ø0.128 (TYP 12 PLACES)

GRAIN DIRECTION

FLAT LAYOUT



0.62

3.400

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 314076